

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D212-664 REV. 9
REF. CANADIAN STC: SH01-9
REF. FAA STC: SR01298NY
REF. EASA STC: EASA.IM.R.S.01304

PURPOSE

To improve paint adhesion on D412-664-403 Crosstubes.

CHANGE

When refinishing D412-664-403 Crosstubes, it is recommended to prepare the metal surface with a pre-treatment as outlined below prior to applying the primer/paint:

1. Ensure the stainless steel substrate is free of contamination (dirt, oil, grease, etc) by applying Axalta 13205S Aluminum Cleaner per manufacturer's instructions.
2. Apply Axalta Metalok 230S Adhesion Promoter or DOD-P-15328D Wash Primer per manufacturer's instruction to the clean metal surface.
3. After application of the pre-treatment, apply MIL-P-85582 or MIL-P-23377 primer, and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish per section 5.3.9 of ICA-D212-664.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

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